

Date: Wednesday, 6/6/2007 1:58:27 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 84 BRACKET
 Job Number : 32800
 Estimate Number : 11034
 P.O. Number :
 This Issue : 6/6/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D28031
 First Issue : / / Type : MACHINED PARTS Drawing Number : D2803 REV B
 Previous Run : 29403 Material :
 Due Date : 6/30/2007 Qty: 10 Um: Each
 Written By :
 Checked & Approved By : 07.06.07
 Comment : Est. A 00.11.06 New Issue EC
 Est Rev:B Blanks Now Cut on Waterjet 06-06-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X10000 6061-T6 Bar .50" x 10.0"



Comment: Qty.: 2.0125 f(s)/Unit Total : 20.1254 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: M102741 +1

ml 07.06.16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per template DT8533

Dwg Rev: B

Prog Rev: B

ml 07.06.16

(10)

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

36 07.08.15 10

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

36 07.08.15 10

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

36 07.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 2803-1 ~~D3280~~ PAR #: N/A Fault Category: Prod/Machine NCR: Yes No DQA: 12 Date: 07/08/14
 QA: N/C Closed: JA Date: 07.08.21

NCR: <u>32800</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-08-14	3	Flat on round end of part caused by mis-alignment of blank, operator error.	<u>[Signature]</u> 07/08/14	More care taken when aligning part on fixture. Destroy & Replace	<u>[Signature]</u> 07-08-14	<u>[Signature]</u> 07-08-14	<u>[Signature]</u> 07/08/13	<u>[Signature]</u> 07-08-14

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:58:27 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 32800

Part Number: D28031

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

07-08-15

(10)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/17

(10)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

BP/m.k

07-08-17

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07/08/17 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-20

Job Completion



07-08-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32800
Description: Bracket		Part Number: D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

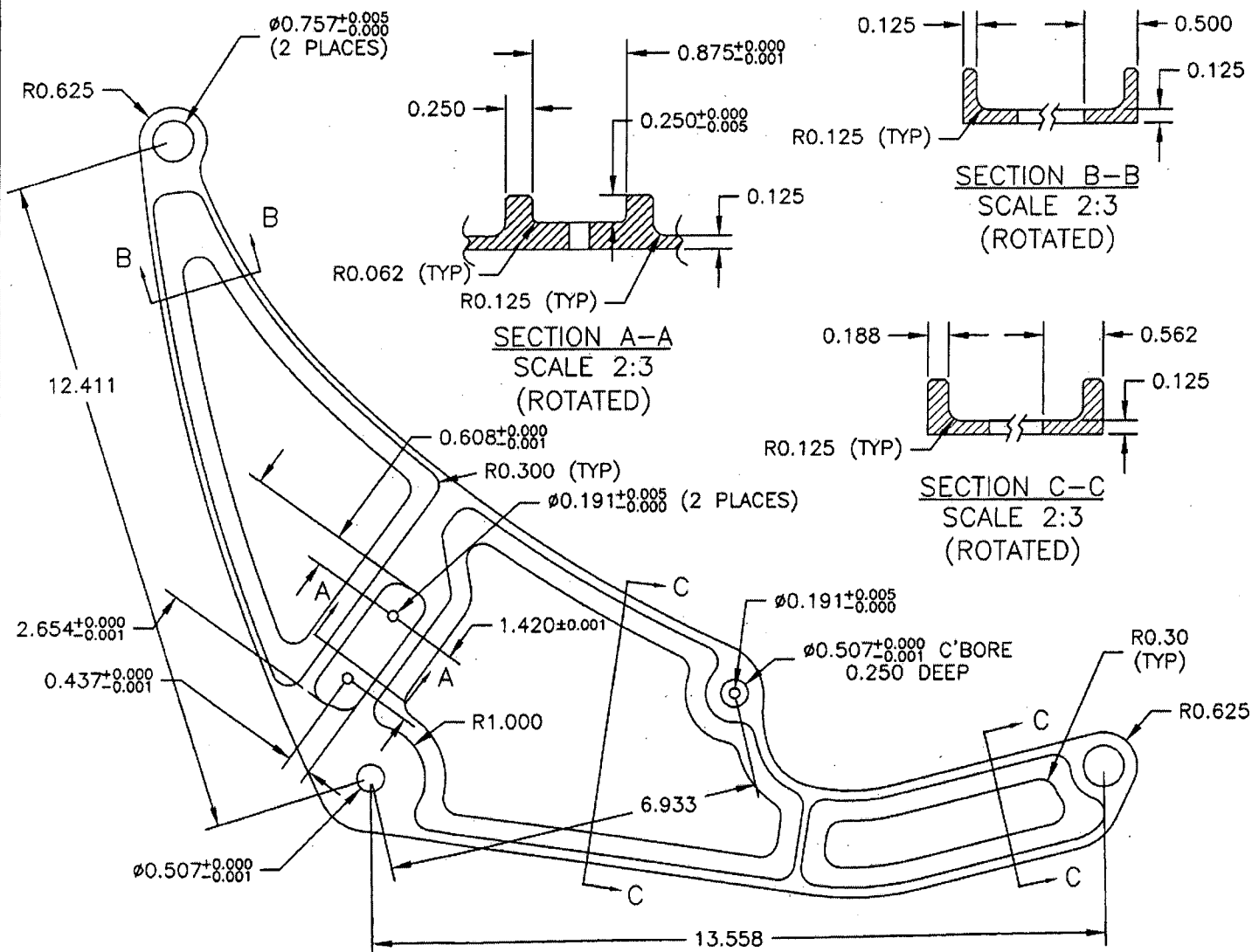
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	+/-0.010					N/L on DWG
Ø0.757	+0.005/-0.000	.757	✓			
Ø0.191	+0.005/-0.000	.191	✓			
Ø0.507	+0.000/-0.001	.506	✓			
13.558	+/-0.010	13.558	✓			
Ø0.507	+0.000/-0.001	.506	✓			
12.411	+/-0.010	12.411	✓			
2.654	+0.000/-0.001	2.653	✓			
0.437	+0.000/-0.001	.4365	✓			
1.420	+/-0.001	1.420	✓			
6.933	+/-0.010	6.933	✓			
0.250	+/-0.010	.252	✓			
0.875	+0.000/-0.001	.8743	✓			
0.250	+0.000/-0.005	.249	✓			
0.125	+/-0.010	.127	✓			
0.125	+/-0.010	.131	✓			
0.125	+/-0.010	.130	✓			
0.125	+/-0.010	.132	✓			
0.500	+/-0.010	.492	✓			
0.562	+/-0.010	.561	✓			
0.188	+/-0.010	.190	✓			

Measured by: BG	Audited by: JL	Prototype Approval:	N/A
Date: 07-08-15	Date: 07/08/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803
				REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED05-03-11 *[Signature]***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

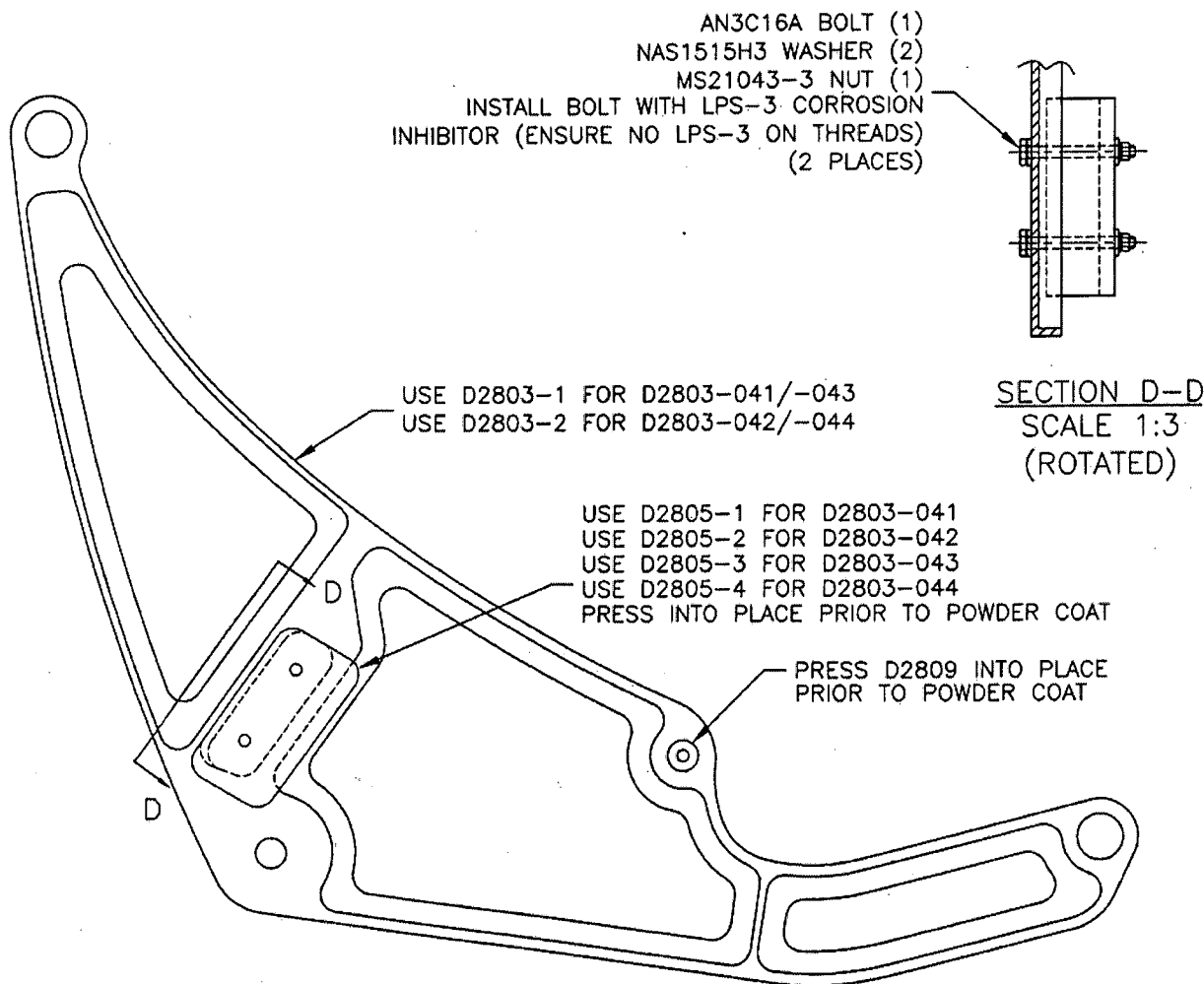
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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